



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A93-3205-00T
Job Sheet 170540



Part No: RBE350A93-3205-00T

Job Qty: 6 ea

Part Name: Tail Rotor Gear Box Input Flange Holding Wrench



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3205-00T Rev 3C IPP Rev A 17.12.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		1/30/18	0.00	0.00	Start Up Waterjet		DL 18/01/17
100	Waterjet	6 pcs		1/30/18	0.00	0.60	Waterjet 2 OMAX		DL 18/01/17
110	QC	6 pcs		1/30/18	0.00	0.00	QC2 Waterjet-4		DL 18/01/17
120	Mori Seiki	6 pcs		1/30/18	0.00	1.50	MORI NV5000-2		DL 18/01/30
130	QC	6 pcs		1/30/18	0.00	0.00	QC2-2		DL 18/01/30
140	QC	6 pcs		1/30/18	0.00	0.00	QC8		DL 18-02-06
170	Outsource	6 pcs		1/30/18	0.00	0.00	Outsource4		DL 18/01/22
180	Packaging	6 pcs		1/30/18	0.00	0.00	Packaging2		DL 18/02/09
190	QC	6 pcs		1/30/18	0.00	0.00	QC6		DL 18/02/09
200	Small Fab	6 pcs		1/31/18	0.00	0.50	Small Fab-8		DL 18/02/09
205	QC	6 pcs		1/31/18	0.00	0.00	QC5		DL 18/02/09
206	Packaging	6 pcs		1/31/18	0.00	0.00	Packaging3-2		DL 18/02/09
210	QC21-FG	6 Ea		1/31/18	0.00	0.00	QC21		DL 18/02/09

Part Op 100 - 1-Cut as per Dwg Dwg Rev: 3C Prog Rev: 3C 2-Deburr if necessary
Descriptions: 120 - 1-Machine as per folio FB 744 FOLIO REV: _____ DWG REV: _____ 2-Deburr
3-Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.
170 - -Issue P/O to ATG: 035709 -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required
200 - Pick, bag and tag

FEB 12 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6 0.250X5-000	2	0	0	0
200-Small Fab	AN315-5	18	0	0	0
	AN5-7	18	0	0	0
	NAS1149F0563P	66	66	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S033138

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Tail Rotor Gear Box Input Flange Holding Wrench

PART NO: RBE350A93 - 3205 - 00T

Original Serial #: S033138

Revision:

Operation:

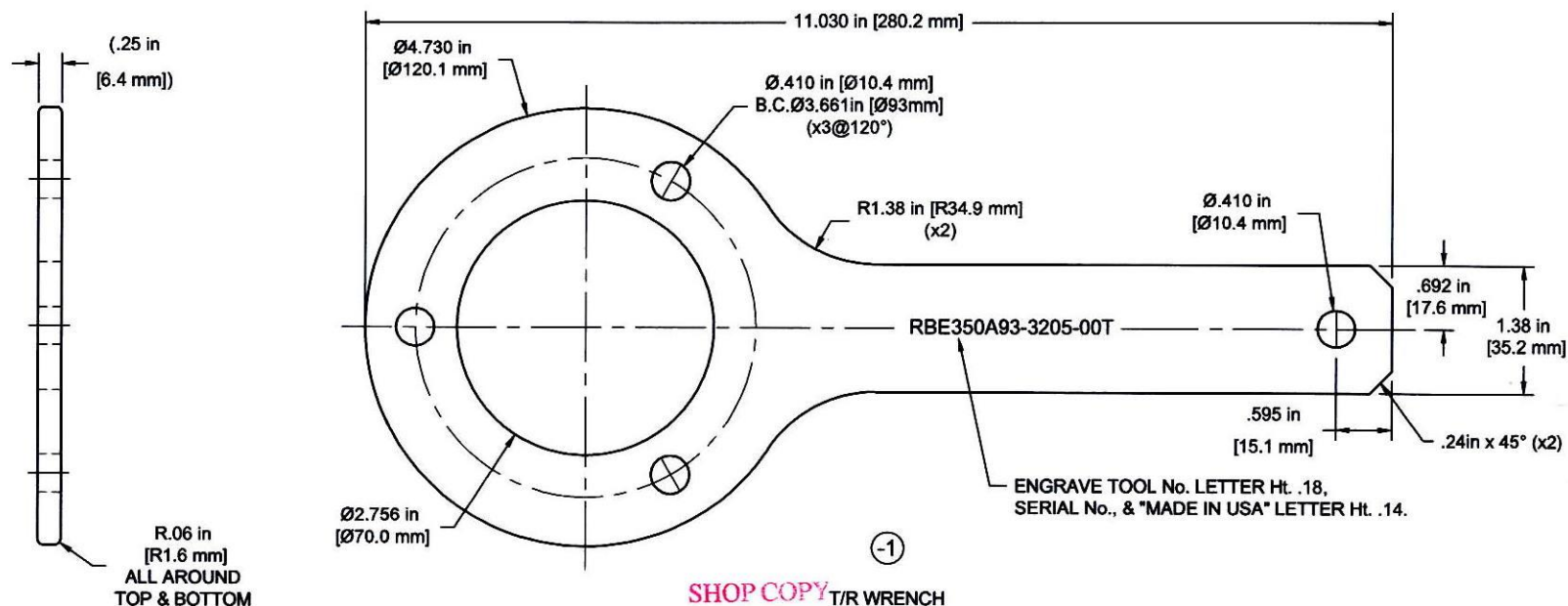
Change No:

Start up Operation 01/17/18

Job No: 170540

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED FLAT WASHER AND CHANGED FROM LOCK NUT TO REGULAR NUT PER SAMPLE. ALSO ADDED ENGRAVING NOTE FOR S/N ECT.	5/12/09	WP	RW
2	CHANGED -01 WRENCH HOLES FROM Ø.410 TO Ø.402, AND HANDLE .236 CHAMFERS TO R.197, ALSO ENLARGED -01 CENTER HOLE FROM Ø2.756 TO Ø2.768 PER HELI PRODUCTS TOOLS. A "T" WAS ADDED TO THE END OF THE TOOL No. TO IDENTIFY THE DIFFERENCE FROM THE ENGINE FLANGE WRENCH.	9/29/09	WP	DW
3	REMOVED ALL OF REV. 2 CHANGES.	2/17/10	WP	G.E.
3A	ADDED MISSING R.063 ALL AROUND TOP & BOTTOM DIM. PER G.E. CH'D FLAT WASHER P/N FROM AN960-616 TO AN960-516.	2/19/10	RJC	RW
3B	CORRECTED FINISH SPEC, CH'D BOM FROM -00T TO -1 PER R.W.	2/18/11	RJC	RW
3C	CORRECTED T/JN WAS RBEA93-3205-00T IS RBE350A93-3205-00T. CH'D DIMENSION PRECISION FROM .xxx TO .xx ON NON-CRITICAL PARTS.	11/5/13	RJC	RW



FUNCTION: USED TO HOLD TGB INPUT FLANGE DURING INPUT SHAFT NUT REMOVAL OPERATION.

SHOP COPY T/R WRENCH
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

WORK ORDER
170539 MJS
18-01-17

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
			-1	1	T/R WRENCH	6061	1/4 x 4-3/4 x 11-1/8
		B/O		3	HEX HEAD CAP SCREW	STEEL	5/16-24 UNF x 31/32 AIRCRAFT SPRUCE #AN5-7
		B/O		3	NUT	STEEL	5/16-24 UNF AIRCRAFT SPRUCE #AN315-5
		B/O		3	FLAT WASHER	STEEL	Ø5/16 I.D. AIRCRAFT SPRUCE #AN960-516
	ASSY 6						

 RED BARN MACHINE			
TITLE TAIL ROTOR GEAR BOX INPUT FLANGE HOLDING WRENCH			
DWG NO. RBE350A93-3205-00T			REV 3C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° .X ± .1		APPROVED <i>D. Mail</i> HEAT TREAT FINISH BLACK ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS II	
UNLESS OTHERWISE SPECIFIED 1. 015 ± .015 SHARP EDGES 0.15 ± .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL EUROCDPTER AS350/355	
SCALE NTS	DATE 10-22-08	SHEET 1 of 1	

$$\begin{array}{r} 250 \\ 204 \\ \hline 44 \end{array}$$

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
										QC / QA Coordinator Approval															
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914649

Date: 22-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
2 ea	Part: 647.2114 Upper U Channel Anodize as per MPP-172 sect. 2.1 2 -Pretreatment as per MPP-172 sect 3.3 3-Prime as per MPP-172 sect 4.3 Job: 22527	Rev: E PO: PO038709 Line: 1	
6 ea	Part: RBE350A93-3205-00E Engine G/B Input Flange Hoidin Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (4 - 1 mils). Water Sealant Job: 22531	Rev: 2A PO: PO038709 Line: 5	
6 ea	Part: RBE350A93-3205-00T Tail Rotor Gear Box Input Flan Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (4 - 1 mils). Water Sealant Job: 22533	Rev: 3C PO: PO038709 Line: 7	DAS 11 9-89
10 ea	Part: RBWSI-HT-12AS-3 Base Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (4 - 1 mils). Water Sealant Job: 22534	Rev: E PO: PO038709 Line: 8	DAS 38 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: 22/2/18 Certified Signature: [Signature] Receiver Signature: _____ Made in Canada.			



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Canada

Tel (613) 632-5200

PURCHASE ORDER PO038709

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			Doubler Issue P/O to ATG: _____ AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N As Per Dwg 647.0100 Rev. B							
7	170540	RBE350A93-3205-00T	Tail Rotor Gear Box Input Flange Holding Wrench -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3205-00T Rev/ 3C	Firmed	2/21/18	6 pcs ✓ 6x	0 pcs	6 pcs	\$20.12/pcs	\$120.72
8	171524	RBWSI-HT-12AS-3	Base -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As per Dwg RBWSI-HT-12AS Rev. E	Firmed	2/21/18	10 pcs ✓ 10x	0 pcs	10 pcs	\$11.65/pcs	\$116.50
Grand Total:									\$963.97	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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